

Work Order ID 110481

110481

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Friday, December 20, 2013 10:18:39 AM

Item ID: D350-636-012 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.
 Start Date: 12/20/2013 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 1/3/2014 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: Date: 12-12-20 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750-042	G								
D3492	C								

100

0.00

100

DOCUMENT CONTROL

DAS

6

9-89

DC

Memo

0.00

Document Control

record fwd angle: 89.9°

Photocopy blue file and type labels per PPP D350-636-012 CHG 007

B110481RH

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Item ID: D350-636-012

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/2013 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/3/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
110	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500"; deburr.								
	4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting								
	5- Drill only two fwd step holes using DT9616. Ensure proper positioning.								
	6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)								
	7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ***SECOND SIDE***								
	8-Open up holes for Detail "K" to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side)								
	9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".								
	10-Open up holes of Detail J to 0.297" (total of 2 holes per side)								

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: <u>M127069</u>								
	12-Grind welds flush as per Dwg D2750								
120	QC10- Inspect visual per QSI004- ground welds	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									

BE 14/01/07

Smp
17/1/17

Smp
17/1/17

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Stop *NS2*

Start Date: 12/20/2013 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 1/3/2014 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/
Run Hours**Tool ID**

Tool #

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

0.00

Quality Control

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Run Start *NR1*

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Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

0.00

160

Skidtubes

Skidtubes

0.00

Memo

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI015

A/R Sikaflex-291 batch: 127097
exp. date: 14/08/16

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)

A/R Aluminum Rod batch: 1127069

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

11-Spot face ground handling holes section (total of 4 places per side) as per

12/01/08

14/01/13

14-01-13 D6L

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	dwg D2750					1	2	14-01-13	DGL
	12-Deburr holes								
170 *170* QC Quality Control	QC10- Inspect visual per QSI004- ground welds	0.00				1			
	Memo	0.00		DAS 27 9-89 14/1/14					
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00				1			
	Memo	0.00		DAS 27 9-89 14/1/14					
	VERIFY C'BOARD IS GOOD								

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00				1	716	14-1-15	
190									
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200		0.00				1	0	0	14-1-17
200									
SprayPaint	Memo	0.00							
Spray Painting	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: <u>126543</u>								
	2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: <u>127762</u>								
210	QC14- Inspect Spray Paint	0.00				1			DAS 05 14-01-20
210									
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
230	HandFinish	0.00							
Hand Finishing	Memo 1-Install inserts as per dwg D2750 2-Inspect for Foreign Objects 3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>14127097</u> EXP DATE: <u>14108</u> 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>1412165</u> 5-Coat all exposed fasteners with "LPS Procyon" batch: <u>14122900</u>								<u>1RH</u> <u>4</u> <u>20</u> <u>12/20/22</u>
240	QC5- Inspect part completeness to step on W/O	0.00							
240	QC	0.00							
Quality Control	Memo								<u>1</u> <u>05</u> <u>14.01.23</u>

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DAS
28
9-89

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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280

QC21- Final Inspection - Work Order Release .

0.00

280

QC

Memo

0.00

Quality Control

MLJ 14-01-30

MLJ 14-01-29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

DQA: _____ Date: _____



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Work Order update only ☐

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Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

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Work Order ID: 110481

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/2013

Required Date: 1/3/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: I02.09.25 Rearranged procedure steps KJ
IPP Rev: J 06-03-29 As per Rev D EC IPP REV: K
AS PER REV F JLM 13-08-22 VERIFIED BY: DD
IPP Rev: K 06-07-13 As per dsi9343 EC
IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC
IPP Rev: M 08-04-22 update steps 4,13 DD verified by: EC
IPP Rev: N 08-09-23 revF as per dwg DD verified by: ec IPP Rev: O
10.06.22 revise seq110 DD verf: EC IPP Rev: P 10.10.01 as
per IIN revH DD verf: EC IPP REV: Q 13.08.27 PER ECN13-
594 DD VERF: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT		Manufactured	No			110	Each	5.0000	1	1			
D2600-3-BENT									**				
Extrusion Bent													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG002		5							
				109789		5							
D2744		Manufactured	No			110	Each	52.0000	1	1			
D2744									**				
Cap													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG001		52							
				100398		28							
				97543		24							
D2739		Manufactured	No			160	Each	11.0000	1	1			
D2739									**				
350 I Beam													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG002		11							
				109712		1							
				109973		10							

Picklist Print

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Start Date: 12/20/2013

Required Date: 1/3/2014

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

160

Each

331.0000

8

8

D2743

Crossbolt Spacer

BE14/01/13

Location

Loc Qty

Loc Code

LG001

331

106245

9

107359

68

107907

122

109799

132

8

D3490-3

Manufactured No

160

Each

160.0000

4

4

D3490-3

Cross Bolt Spacer

BE14/01/13

Location

Loc Qty

Loc Code

LG001

160

103883

14

105603

3

107913

63

109933

80

4

D3490-1

Manufactured No

160

Each

225.0000

4

4

D3490-1

Cross Bolt Spacer

BE14/01/13

Location

Loc Qty

Loc Code

LG001

225

107419

57

109932

168

4

D3631-1

Manufactured No

230

Each

12.0000

8

8

D3631-1

Washer

11/01/22

Location

Loc Qty

Loc Code

FP001

12

107324

12

B110258

8

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Shop Packet Print

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Picklist Print

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Start Date: 12/20/2013

Required Date: 1/3/2014

Start Qty: 1.00

Required Qty: 1.00

D3791-1

Manufactured No

230

Each

3.0000

1

1

D3791-1

Wearpad

**

HL 12/01/22

Location

Loc Qty

Loc Code

FP002

3

106144

3

D3793-3

Manufactured No

230

Each

11.0000

1

1

D3793-3

Wearplate Aft

**

HL 12/01/22

Location

Loc Qty

Loc Code

FP001

11

104212

11

MS21043-6

Purchased No

230

Each

268.0000

4

4

MS21043-6

NUT

**

HL 12/01/22

Location

Loc Qty

Loc Code

FG

20

103693

20

ST315

248

m127255

248

D3794-1

Manufactured No

230

Each

13.0000

1

1

D3794-1

Gasket Fwd

**

HL 12/01/22

Location

Loc Qty

Loc Code

FP001

13

104620

1

108497

5

109207

7

Picklist Print

Friday, December 20, 2013 10:18:45 AM

Page 4

Work Order ID: 110481

110481

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/2013

Required Date: 1/3/2014

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

45.0000

8

8

NAS1611-010

O-RING

**

Handwritten: 11/01/22

Location

Loc Qty

Loc Code

FP001

45

m126988

45

D2741

Manufactured

No

250

Each

39.0000

1

1

D2741

Blade

**

DAS
26
9-89

Location

Loc Qty

Loc Code

FG

11

100664

5

85480

1

98323

5

ST466

28

107206

28

NAS1515H3L

Purchased

No

230

Each

54.0000

4

4

***NAS1515H3L ***

Washer

**

DAS
21
9-89

Location

Loc Qty

Loc Code

FG

40

102472

40

ST297

14

124542

14

NAS1611-013

Purchased

No

230

Each

16.0000

8

8

NAS1611-013

O-RING

**

Handwritten: 11/01/22

Location

Loc Qty

Loc Code

FP001

16

125445

16

Handwritten: M127813

Handwritten: X1

Picklist Print

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Page 5

Work Order ID: 110481

110481

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/2013

Required Date: 1/3/2014

Start Qty: 1.00

Required Qty: 1.00

AN3C6A Purchased No 230 Each 535.0000 4 4

AN3C6A

Bolt

**

Handwritten: 14/01/22

Location Loc Qty Loc Code

FG 10

122416 10

ST513 525

m125709 525

NAS1149C0832R Purchased No 230 Each 359.0000 1 1

NAS1149C0832R

Washer

**

Handwritten: 14/01/22

Location Loc Qty Loc Code

ST292 359

122441 92

m114915 117

m125807 150

D3536-25 Manufactured No 230 Each 20.0000 1 1

D3536-25

Gasket Center

**

Handwritten: 14/01/22

Location Loc Qty Loc Code

FG 6

87053 2

95328 4

FP001 14

109206 14

D3794-3 Manufactured No 230 Each 17.0000 1 1

D3794-3

Gasket Aft

**

Handwritten: 14/01/22

Location Loc Qty Loc Code

FP001 17

108413 17

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Shop Packet Print

Page 5

Picklist Print

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Page 6

Work Order ID: 110481

110481

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/2013

Required Date: 1/3/2014

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

230

Each

164.0000

34

34

AN3C5A

Bolt

**

Handwritten: 11/01/22

Location

Loc Qty

Loc Code

FG

5

122800

5

ST350

159

m127290

159

Handwritten: 1/3/1

D3537-1

Manufactured

No

230

Each

20.0000

3

3

D3537-1

Wearpad

**

Handwritten: 11/01/22

Location

Loc Qty

Loc Code

FG

18

79833

8

88562

10

FP001

2

108118

2

Handwritten: B110341

Handwritten: 1/3

D3535-25

Manufactured

No

230

Each

13.0000

1

1

D3535-25

Wearplate Center

**

Handwritten: 11/01/22

Location

Loc Qty

Loc Code

FG

2

95077

2

FP002

11

106128

11

Handwritten: 1/1

Picklist Print

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Page 7

Work Order ID: 110481

110481

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/2013

Required Date: 1/3/2014

Start Qty: 1.00

Required Qty: 1.00

D3492-3

Manufactured No

230

Each

277.0000

8

8

D3492-3

Plug

HL 12/20/13

Location

Loc Qty

Loc Code

FP001

277

104853

72

107331

105

109800

100

x8

NAS1149C0332R

Purchased No

230

Each

9,497.000

38

38

NAS1149C0332R

WASHER

HL 12/20/13

Location

Loc Qty

Loc Code

GA

1277

125654

1277

st510

8220

m126319

2720

m127306

2500

m127410

3000

x38

D3488-042

Manufactured No

230

Each

9.0000

1

1

D3488-042

Blade Fitting RH

HL 12/20/13

Location

Loc Qty

Loc Code

FP001

9

106658

6

98887

3

B109134

x1

Picklist Print

Friday, December 20, 2013 10:18:46 AM

Page 8

Work Order ID: 110481

110481

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/2013

Required Date: 1/3/2014

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

230

Each

469.0000

38

38

ALS4-1032-225

Rivnut

ll 14/01/22

Location

Loc Qty

Loc Code

FG

30

M127028

30

ST280

10

M127028

10

st555

429

M127092

429

x38

D3492-1

Manufactured

No

230

Each

195.0000

8

8

D3492-1

Plug

ll 14/01/22

Location

Loc Qty

Loc Code

FP001

195

104844

195

x8

D3793-1

Manufactured

No

230

Each

6.0000

1

1

D3793-1

Wearplate Fwd

ll 14/01/22

Location

Loc Qty

Loc Code

FP002

6

109205

6

x1

AN8C35A

Purchased

No

230

Each

75.0000

1

1

AN8C35A

Bolt

ll 14/01/22

Location

Loc Qty

Loc Code

FG

4

121275

4

FP001

71

m126293

47

m127061

24

x1

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Shop Packet Print

Page 8

Picklist Print

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Page 9

Work Order ID: 110481

110481

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/2013

Required Date: 1/3/2014

Start Qty: 1.00

Required Qty: 1.00

MS21083C8	Purchased	No	230	Each	35.0000	1	1	
MS21083C8								** <u>HL 11/01/22</u>
Nut								

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST319	35				
			m127255	35				<u>✓</u>
D2745	Manufactured	No		230	Each	129.0000	8	8
D2745								** <u>HL 11/01/22</u>
Bushing								

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST017	129				
			106847	5				<u>✓</u>
			107336	124				
AN6C44A	Purchased	No		230	Each	56.0000	4	4
AN6C44A								** <u>HL 11/01/22</u>
Bolt								

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			FG	2				
			103964	2				
			ST340	50				
			123900	50				
			ST341	4				
			m127300	4				<u>✓</u>
D3532-1	Manufactured	No		250	Each	86.0000	2	2
D3532-1								** <u>HL 1-1-24</u>
Spacer								

DAS
6
9-89

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	ST054	86	
	100519	26	
	109803	60	

2x

DAS
26
9-89

Picklist Print

Friday, December 20, 2013 10:18:46 AM

Page 10

Work Order ID: 110481

110481

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/2013

Required Date: 1/3/2014

Start Qty: 1.00

Required Qty: 1.00

MS21083C8 Purchased No 250 Each 35.0000 2 2

MS21083C8

Nut

**

DAS
26
9-89

Location Loc Qty Loc Code

ST319 35

m127255 35

250 Each 991.0000 2 2

NAS1149D0863J³

Purchased No

NAS1149D0863J

Washer

**

DAS
26
9-89

Location Loc Qty Loc Code

FP001 6

118078 6

ST293 185

125484 185

ST510a 800

125268 600

125635 200

250 Each 245.0000 2 2

D3493-1

Manufactured No

D3493-1

Washer

**

DAS
26
9-89

Location Loc Qty Loc Code

FG 10

97201 10

ST051 235

105613 16

107916 60

109105 159

DAS
6
9-89

DAS
26
9-89

***ONLY INSTALL IF INSTALLING ON APICAL
FLOAT SYSTEM***

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Shop Packet Print

Page 10

Picklist Print

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Page 11

Work Order ID: 110481

110481

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/2013

Required Date: 1/3/2014

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

45.0000

2

2

AN8C21A

Bolt

14-1-24

DAS
26
9-89

Location

Loc Qty

Loc Code

ST

2

123966

2

ST505

43

m127061

43

DAS
6
9-89

DAS
9-89

2x

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X			D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
11	1	1	1	D2744	CAP
18	8	8	8	D2745	BUSHING
11				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

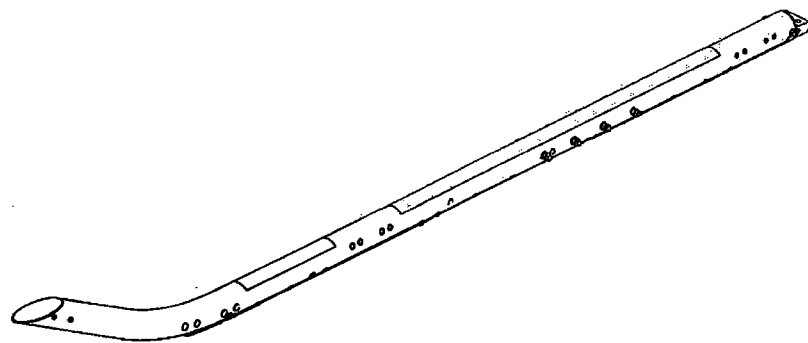
GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH; ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2, 1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

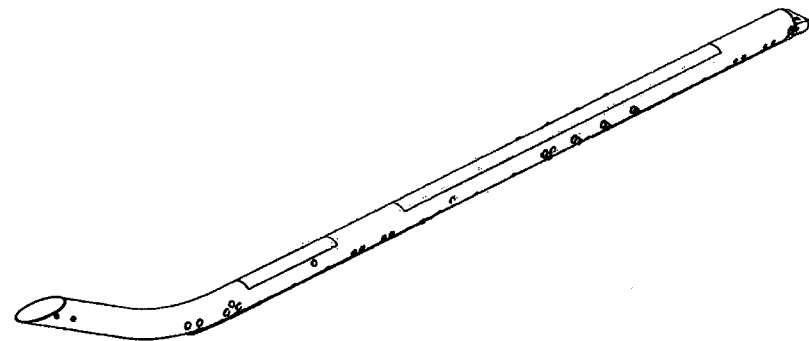
G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS $+0.010/-0.000$, WAS $+0.100/-0.000$ (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3; REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DED 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 1 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

13-12-20
WB-12-20

RELEASED
2013-08-13



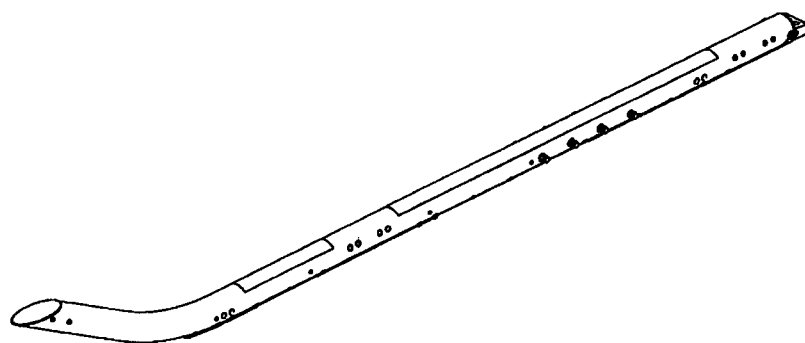
D2750-041 350 SKIDTUBE ASSEMBLY, LH



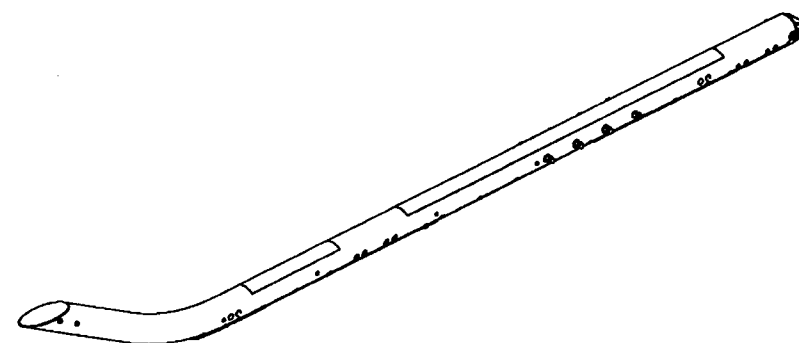
D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2013-08-13
MD

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	<i>[Signature]</i>	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D2750	REV. G
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 11	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	<small>COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



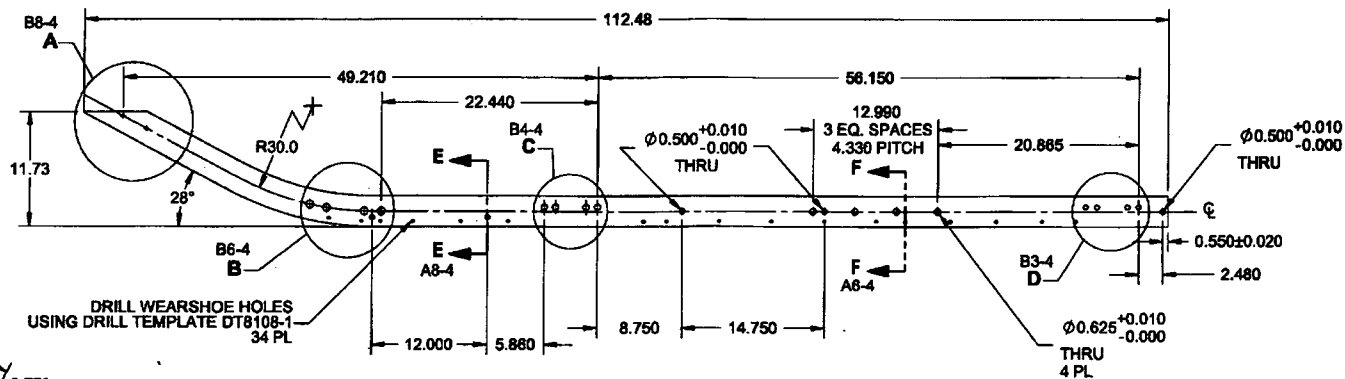
D2750-043 350 SKIDTUBE ASSEMBLY, LH



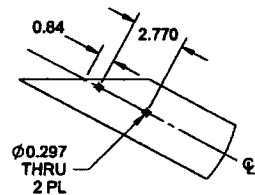
D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2013-08-13
wp

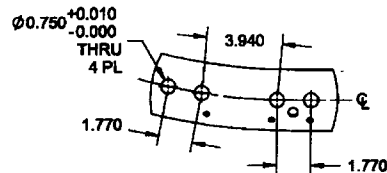
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2750	SHEET 3 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



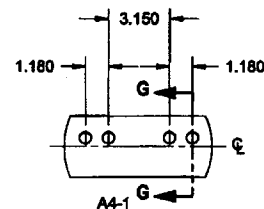
D2750-1 LH SKIDTUBE



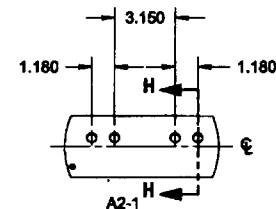
DETAIL A
SCALE 2X



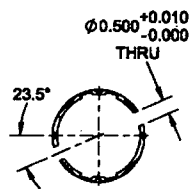
DETAIL B
SCALE 2X



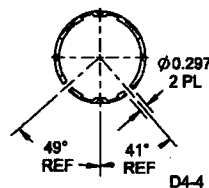
DETAIL C
SCALE 2X



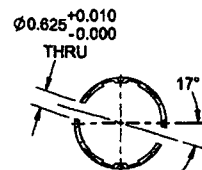
DETAIL D
SCALE 2X



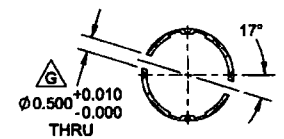
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL

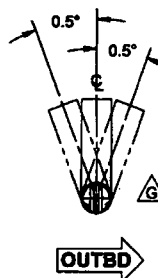
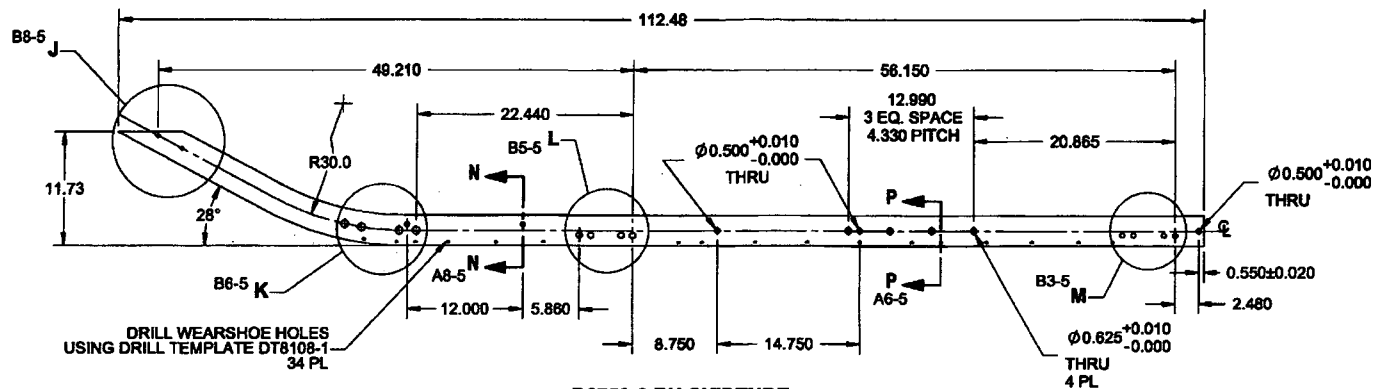


SECTION H-H
SCALE 3X, 4 PL

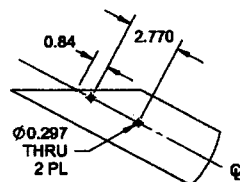
RELEASED
2013-08-13

DESIGN	MM	DART AEROSPACE USA, INC.
DRAWN		KENT, WA
CHECKED		DRAWING NO. D2750
MFG. APPR.		REV. G
APPROVED		SHEET 4 OF 11
DE APPR.		TITLE SCALE
DATE	13.07.11	350 SKIDTUBE ASSEMBLY NTS

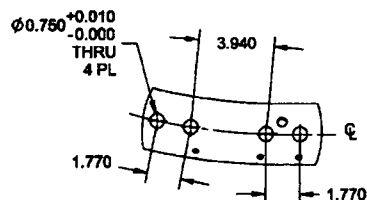
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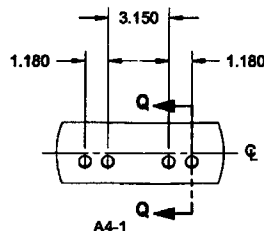
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TWIST ON FWD BEND
(VIEWED LOOKING FWD)



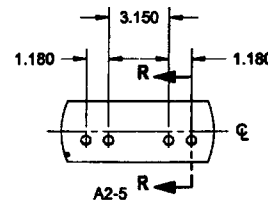
DETAIL J
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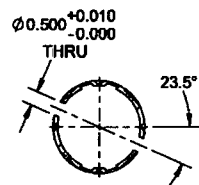
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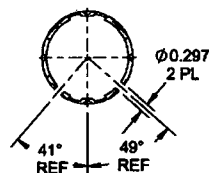
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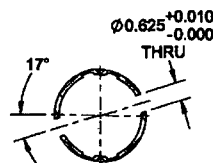
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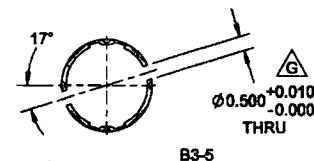
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL

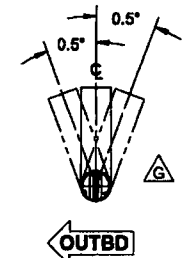
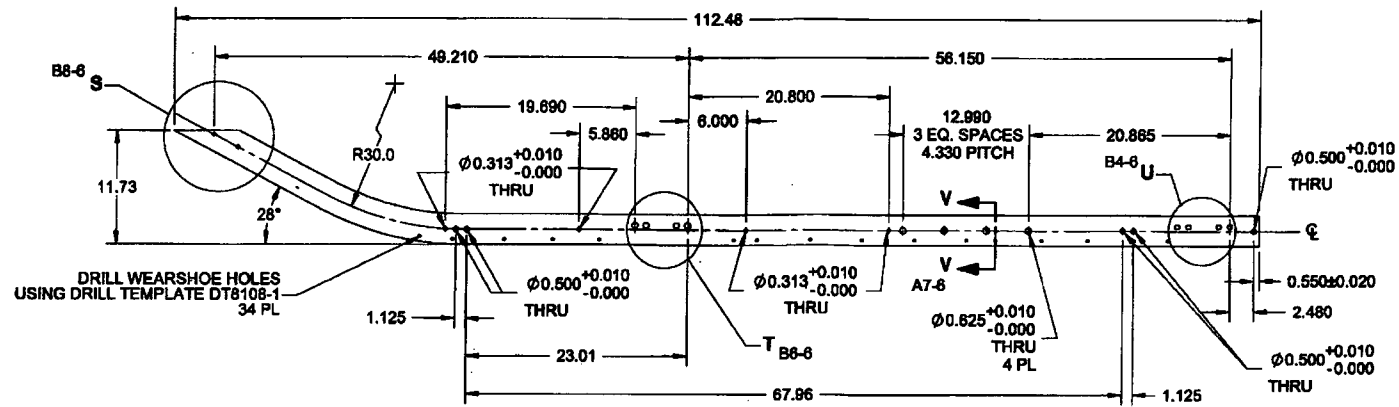


SECTION R-R
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2013-08-13
JMM

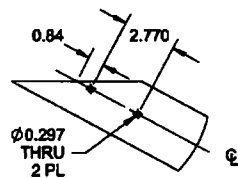
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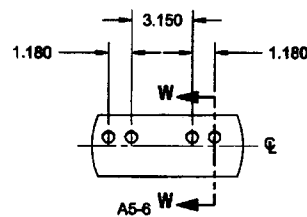


MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

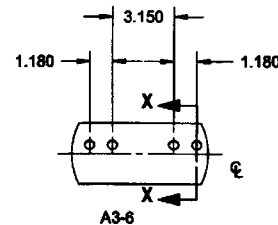
D2750-3 LH SKIDTUBE



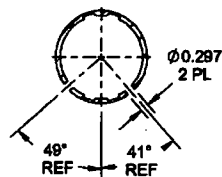
DETAIL S
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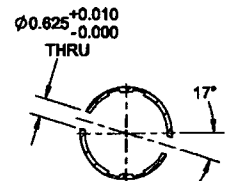
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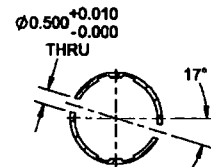
DETAIL U
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SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL

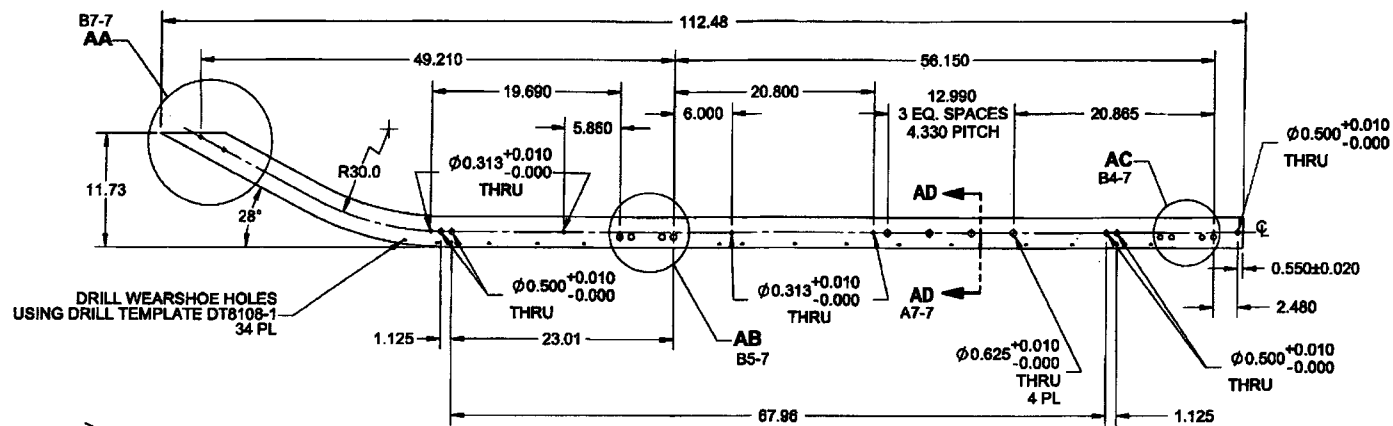


SECTION X-X
SCALE 3X, 4 PL

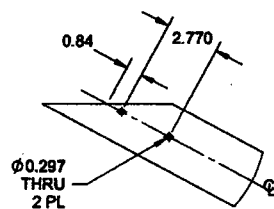
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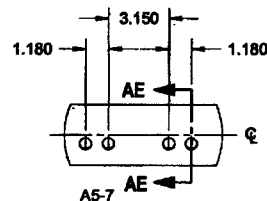
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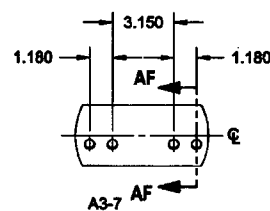
D2750-4 RH SKIDTUBE



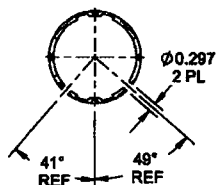
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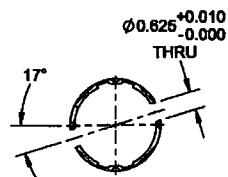
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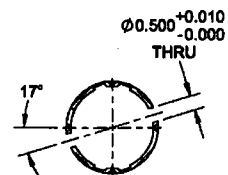
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



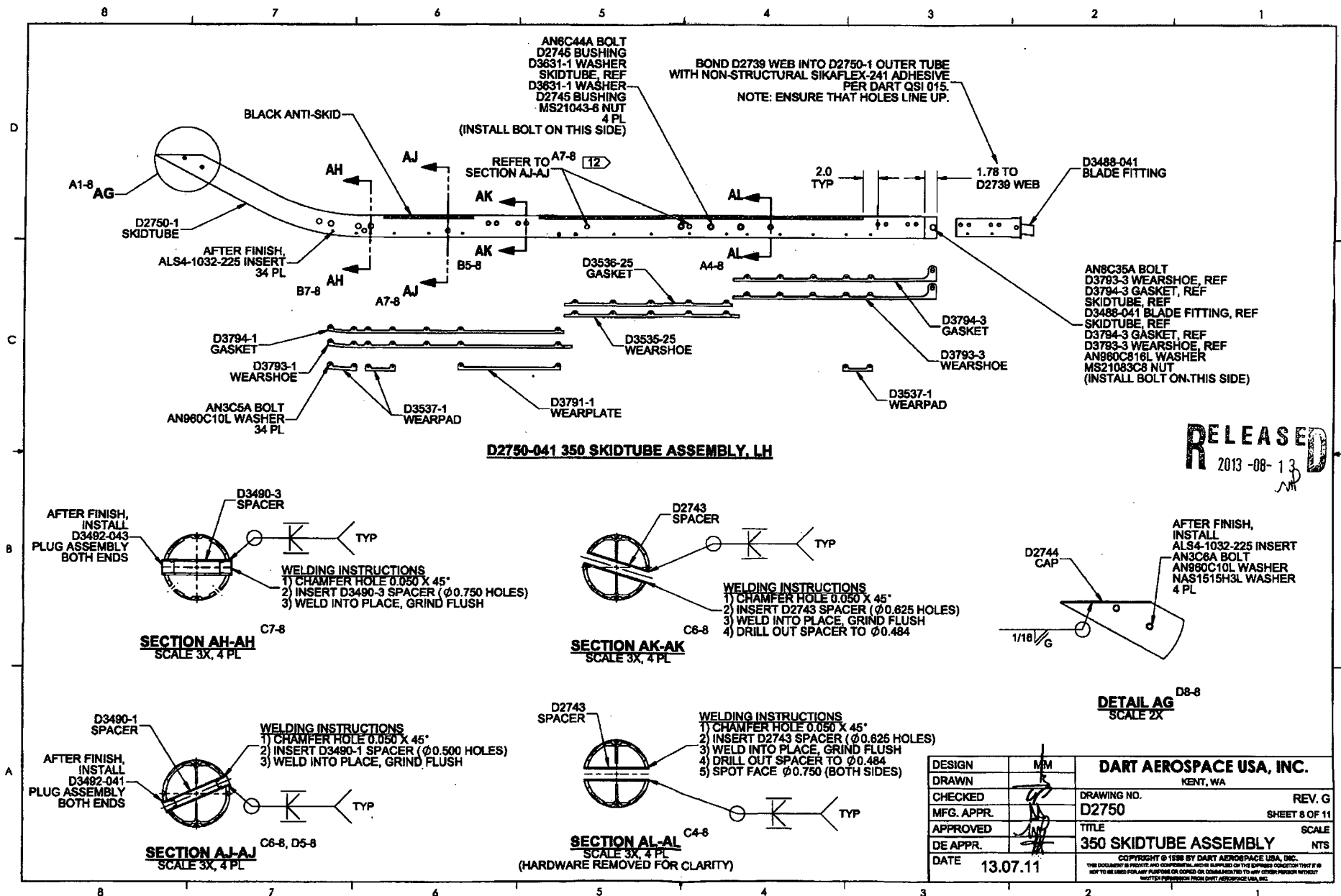
SECTION AE-AE
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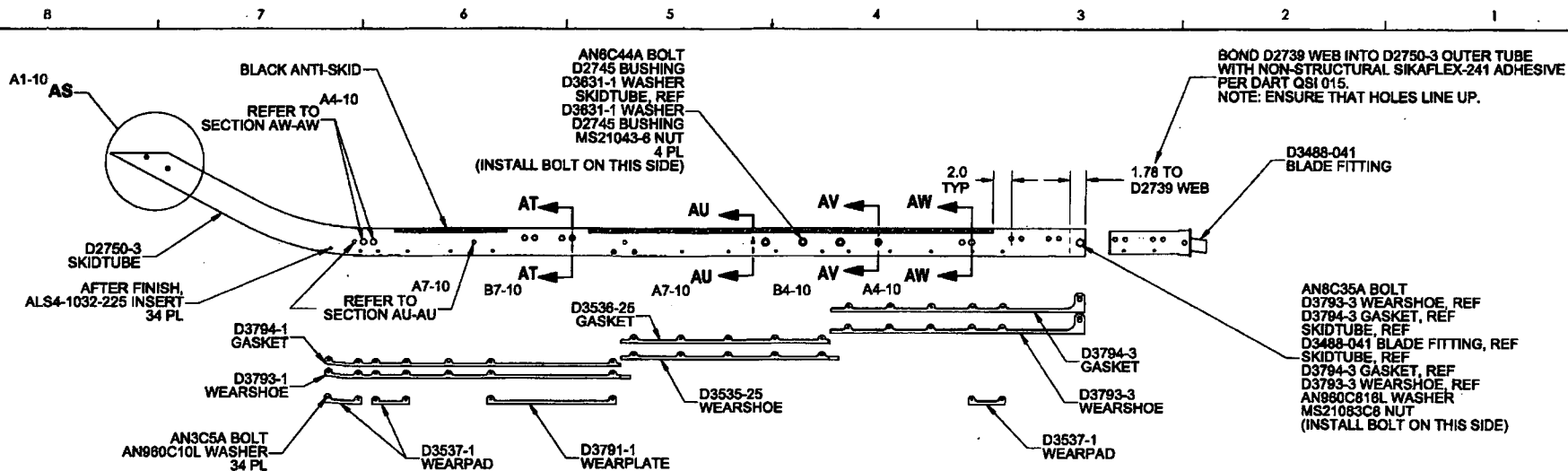


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2013-08-13

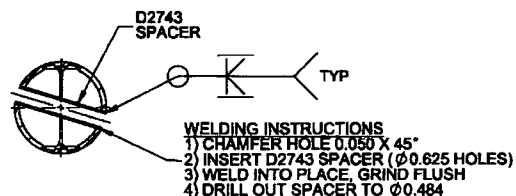
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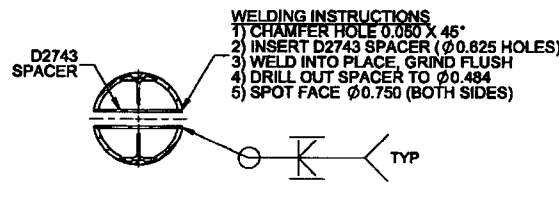


D2750-043 350 SKIDTUBE ASSEMBLY, LH

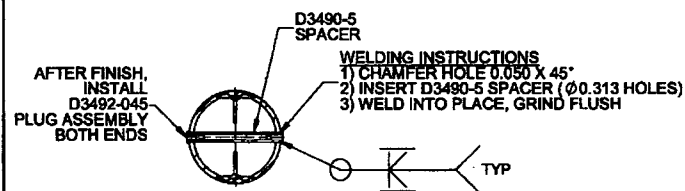
RELEASE
2013-08-13



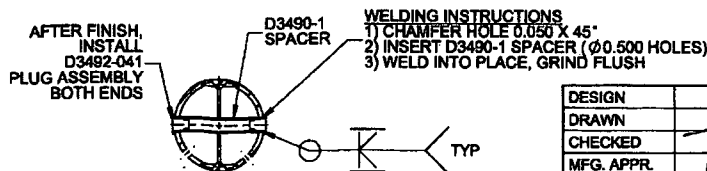
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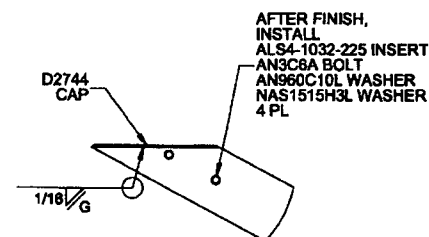
SECTION AV-AV
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(HARDWARE REMOVED FOR CLARITY)



SECTION AU-AU
SCALE 3X, 4 PL



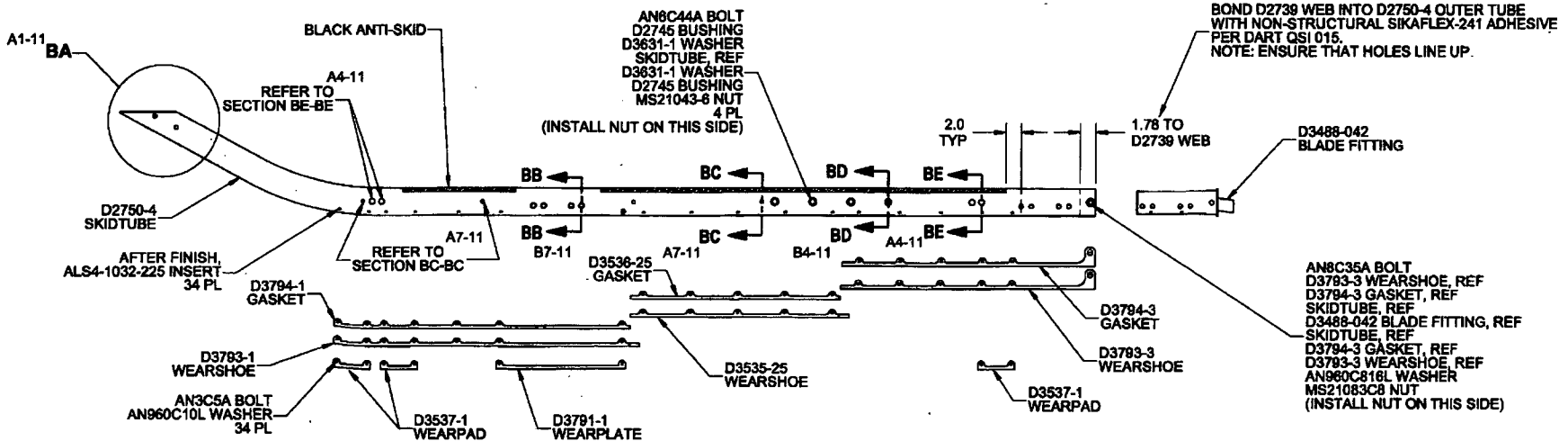
SECTION AW-AW
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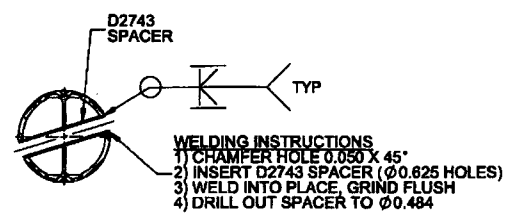
DETAIL AS
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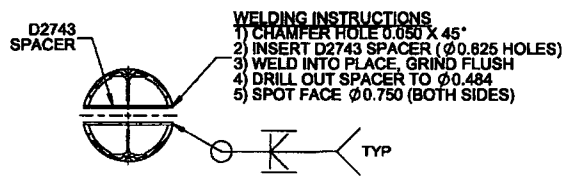
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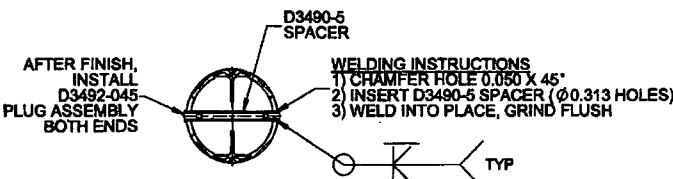
D2750-044 350 SKIDTUBE ASSEMBLY, RH



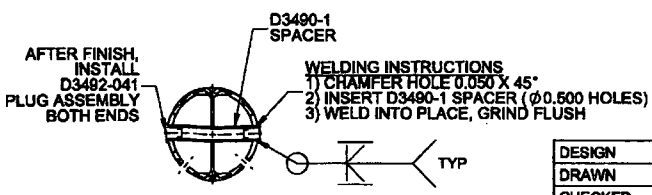
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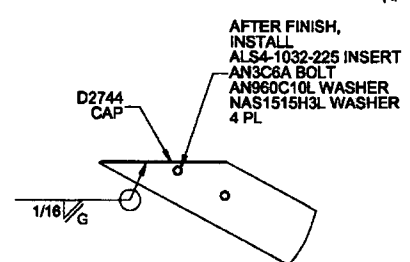
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

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8 7 6 5 4 3 2 1

No. 337

**AWS D17.1/D17.1M:2010
SKIDTUBE WELDING TEST RECORD**

Name: Barclay Elliott
Job #: B109371
Part #: D350-636-012
Description: 350 skid tube
Welding Process: TIG [☒] MIG [☐]
Base Material: Aluminium
Current: AC [☒] DC [☐]

TEST REQUIREMENTS AND RESULTS

Visual:	pass [<input checked="" type="checkbox"/>] fail [<input type="checkbox"/>]
Penetration:	pass [<input checked="" type="checkbox"/>] fail [<input type="checkbox"/>]
Fusion:	pass [<input checked="" type="checkbox"/>] fail [<input type="checkbox"/>]
Cracks:	pass [<input checked="" type="checkbox"/>] fail [<input type="checkbox"/>]
Overlap (cold lap)	pass [<input checked="" type="checkbox"/>] fail [<input type="checkbox"/>]
Undercut:	pass [<input checked="" type="checkbox"/>] fail [<input type="checkbox"/>]
Pin holes:	pass [<input checked="" type="checkbox"/>] fail [<input type="checkbox"/>]
Porosity (surface):	pass [<input checked="" type="checkbox"/>] fail [<input type="checkbox"/>]
Coloration:	pass [<input checked="" type="checkbox"/>] fail [<input type="checkbox"/>]
Burn through:	pass [<input checked="" type="checkbox"/>] fail [<input type="checkbox"/>]

Qualifier: DAS
9
9-89 Date of Test Coupon: 13-12-03
Welder: Barclay Elliott Date of Test Coupon: 13-12-03

The above named individual is qualified to weld in accordance with AWS D17.1/D17.1M:2010.